

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018304**Date Inspected:** 25-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC)**Location:** Shanghai, China**CWI Name:** Li Yang and Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 11EW (Stiffener Plate CJP)

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The weld joint was designated as CSD9-PP108-150. The welder identification was 045175 and was observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-345-FCAW-2G(2F)-Repair-1. The piece mark was identified as the stiffener welded between the Corner Assembly Edge Panel to Floor Beam, Counter Weight side.

Please reference the pictures attached for more comprehensive details.

Segment 11DW

This QA Inspector observed the in-process fillet welding by Flux Cored Arc Welding (FCAW) process. The weld joint was designated as FB203-016-009/010. The welder identification was 040609 and observed welding in the

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2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as stiffener welded at FL3 at PP 106.

Segment 11DW

This QA Inspector observed the in-process fillet welding by Flux Cored Arc Welding (FCAW) process. The weld joint was designated as SP203-016-042/043. The welder identification was 040609 and observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as stiffener welded at FL3 at PP 106.

Cross Beam # 16

This QA Inspector observed the in-process fillet welding by Flux Cored Arc Welding (FCAW) process. The weld joint was designated as SP206-016-042/043. The welder identification was 040609 and observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as stiffener welded at FL3 at PP 104.

Please reference the pictures attached for more comprehensive details.

Segment 11DW to Cross Beam # 16 (Match Drilling)

This QA Inspector observed ZPMC personnel performing match drilling for the Segment 11DW Deck Panel extension to the Cross Beam # 16 Deck Plate between PP 104 to PP 105 and PP 105 to PP 106. Near work point W5.

Please reference the pictures attached for more comprehensive details.

Counter Weight

This QA Inspector observed ZPMC personnel installing the Counter Weight at Segment 11BW, at the Counter Weight side of the West line.

Please reference the pictures attached for more comprehensive details.

Segment 11DW to Segment 11EW

This QA Inspector observed the Visual Test (VT) discontinuities welding by Shielded Metal Arc Welding (SMAW) process. The welder identification was 251194. The piece mark was identified as Longitudinal Diaphragm (LD) at work point W3 and at work point W4.

Segment 11CW to Segment 11DW

This QA Inspector observed the ZPMC personnel installing the splice plates at Transverse Splice T-Ribs at following locations for match drilling the T-Rib to T-Rib flange.

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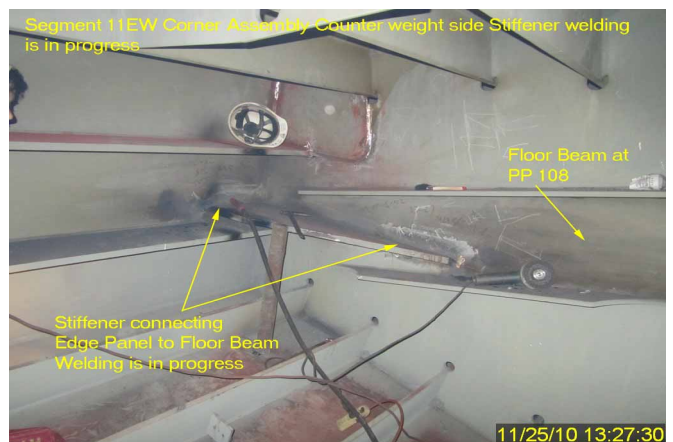
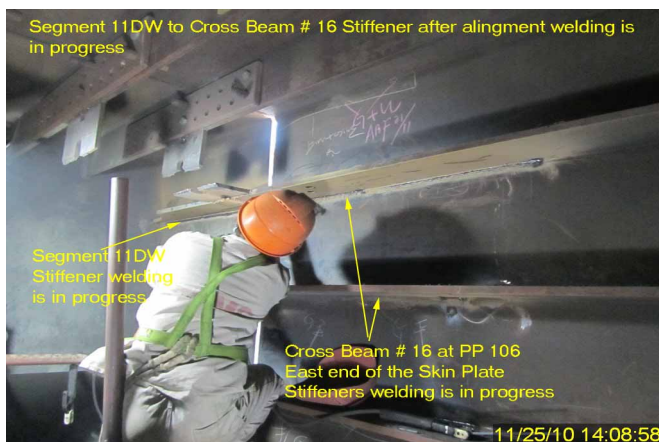
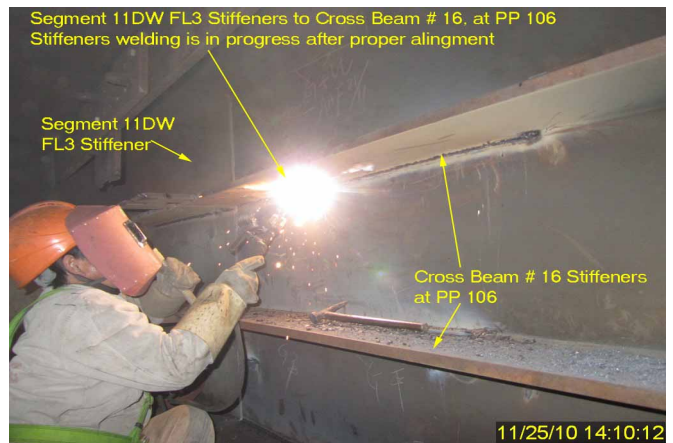
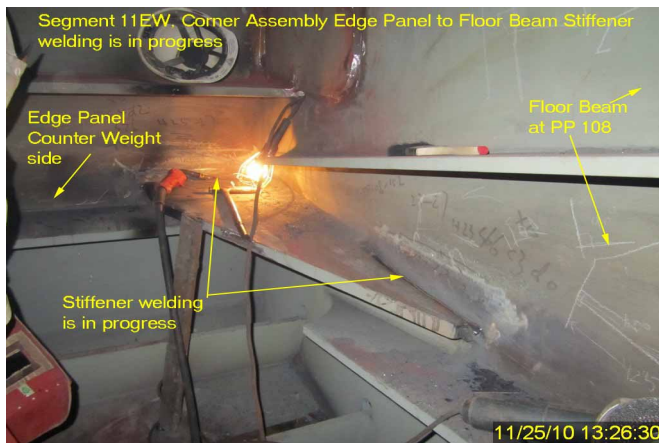
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Side Panel, Bike Path side from work point W6 towards W4.

Bottom Panel from work point W4 towards W3.

Side Panel Cross Beam side from work point W3 towards W1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150000422372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Dsouza,Christopher

QA Reviewer